

Date: Tuesday, 29/04/2008 9:22:49 AM  
 User: Julie Lecocq

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : WEARSHOE
<b>Job Number</b> : 38867	
<b>Estimate Number</b> : 12734	
<b>P.O. Number</b> :	<b>Part Number</b> : D353525
<b>This Issue</b> : 29/04/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3535 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 38162	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/05/2008 <b>Qty:</b> 20 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JLD 08-4-29</u>	
<b>Comment</b> : Est Rev:A New Issue 07-02-15 JLM Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



**Comment:** Qty.: 0.5355 sf(s)/Unit Total: 10.7100 sf(s)  
 304/316 .040 Sheet  
 (M304S20GA)  
 Batch: 107744 HB 8-5-1

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



**Comment:** FLOW WATER JET  
 1-Cut as per Dwg D3535  
 Dwg Rev: B  
 Prog Rev: B

HB 8-5-1

(21)

2-Deburr if necessary HB 8-5-1

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-5-1

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

08/05/07 (420)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



**Comment:** NC BRAKE

1-Form on CNC Brake as per Dwg D3535 using Jigs DT8261 and DT8326  
 2-Form joggle on Punch as per Dwg D3535 using Jig DT8158 Identify as D3535-25

SB 08/05/15

(21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 29/04/2008 9:22:49 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 38867

Part Number: D353525

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/16 (21)

7.0

POWDER COATING

POWDER COATING



M105692



(21X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

2:30

OVEN TEMPERATURE:

320 °F

FINISH TIME:

3:00 PM

M-J 08/05/20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



JL



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-05-20

(X21)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

JL

08-05-20

(X21)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-05-21

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 38867
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3535-25
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.887	X			
1.937	+/-0.010	1.936	X			
1.450	+/-0.010	1.450	X			
5.450	+/-0.010	5.453	X			
10.900	+/-0.010	10.900	X			
16.350	+/-0.010	16.350	X			
21.800	+/-0.010	21.800	X			
Ø0.188	+0.005/-0.001	.191	X			
12.750	+/-0.010	12.750	X			
6.75	+/-0.030	6.755	X			
6.00	+/-0.030	6.00	X			
0.300	+/-0.010	0.303	X			
0.300	+/-0.010	0.305	X			
0.038	+/-0.010	0.037	X			

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 8-5-1	<b>Date:</b> 08/05/01	<b>Date:</b>	N/A

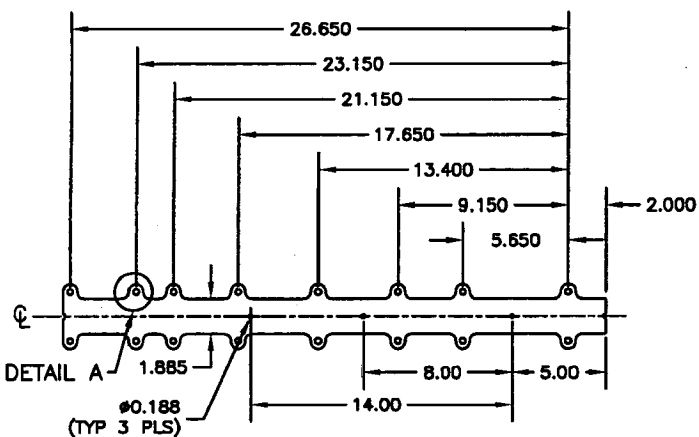
Rev	Date	Change	Revised by	Approved
A	07.11.23	New Issue	KJ/EC/DD	

**DART**

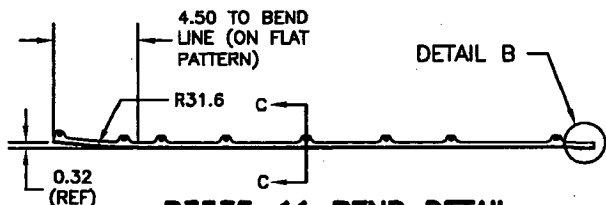
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07.04.24

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
C.B.	M.	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<i>[Signature]</i>	<i>[Signature]</i>	D3535	SHEET 1 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

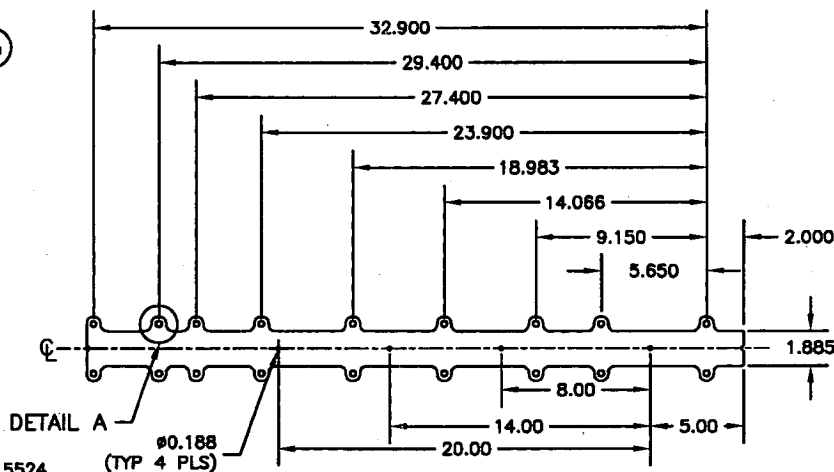


**D3535-11F FLAT PATTERN**

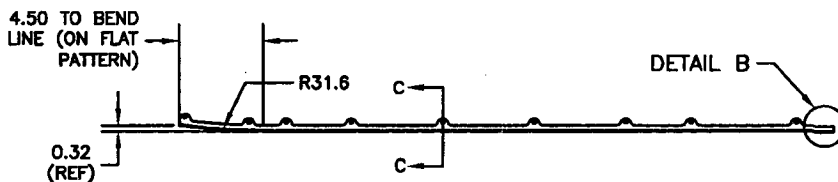


**D3535-11 BEND DETAIL**

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WITHOUT NOTICE  
WORK ORDER  
NO. 38867



**D3535-13F FLAT PATTERN**



**D3535-13 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

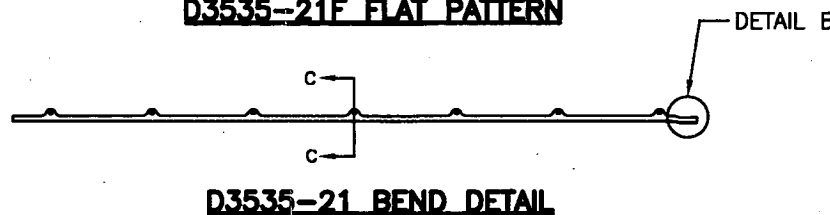
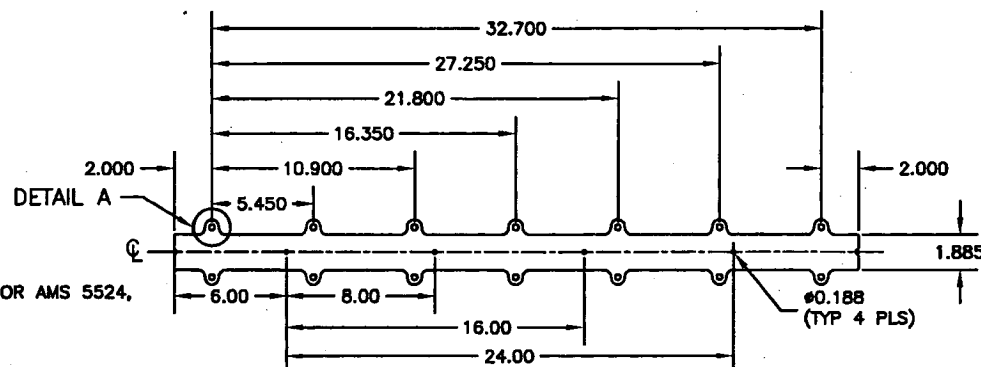
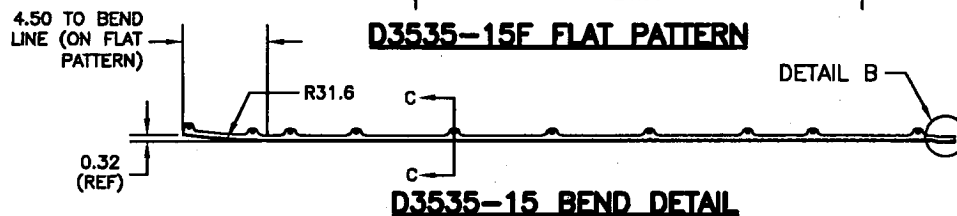
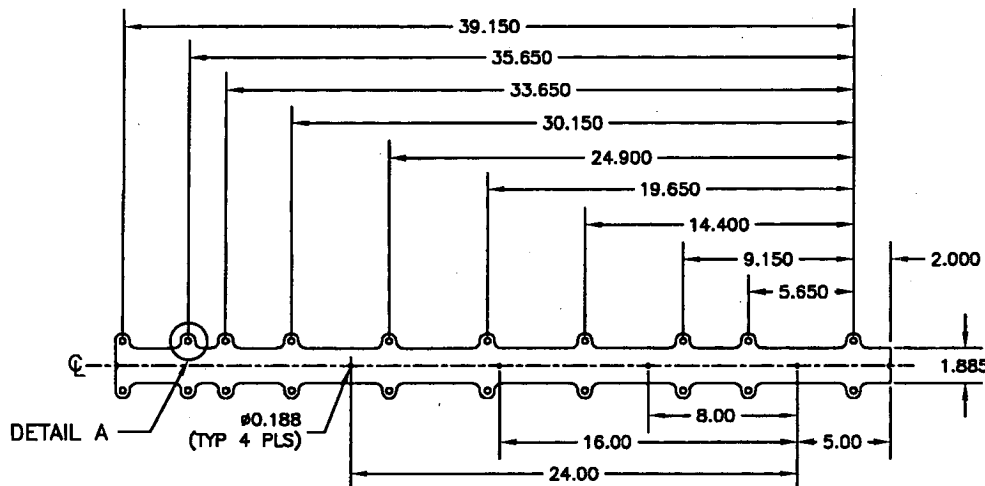
**NOTE:** Date & initial all entries

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		D3535	SHEET 2 OF 7
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

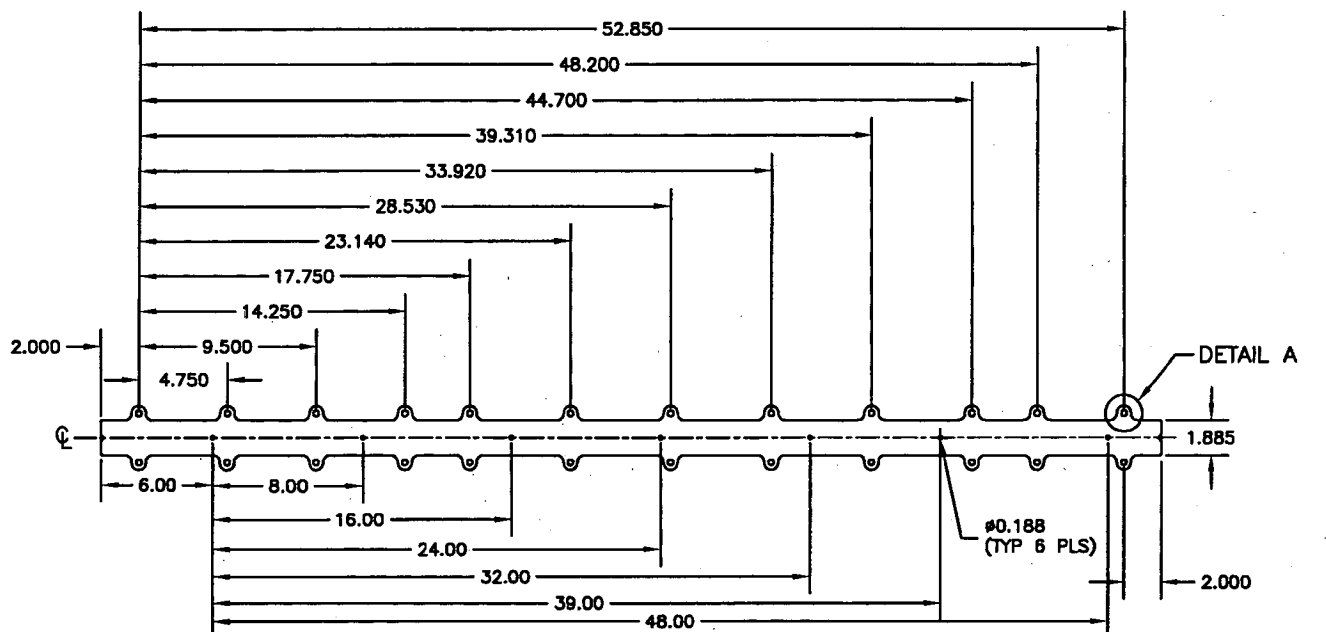
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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**D3535-23F FLAT PATTERN**

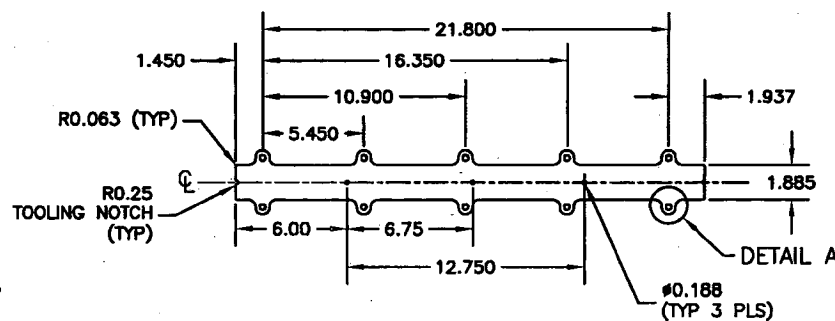


**D3535-23 BEND DETAIL**

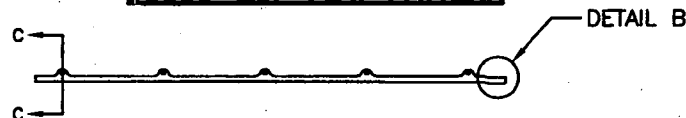
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WORK ORDER  
NO. 388627

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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**D3535-25F FLAT PATTERN**



**D3535-25 BEND DETAIL**

DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		SCALE	1:10	
		SHEET 3 OF 7		
		REV. B		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

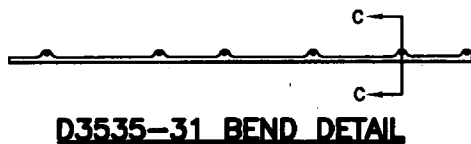
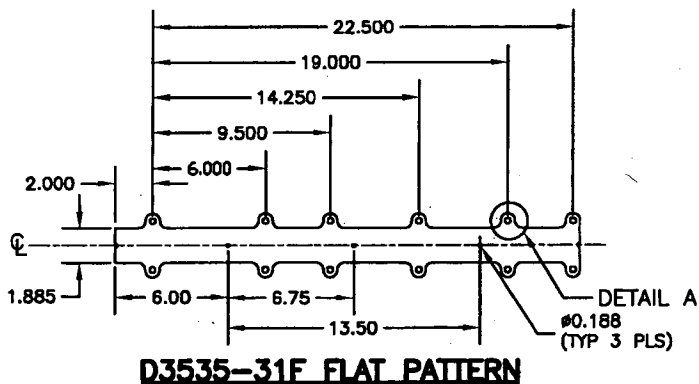
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

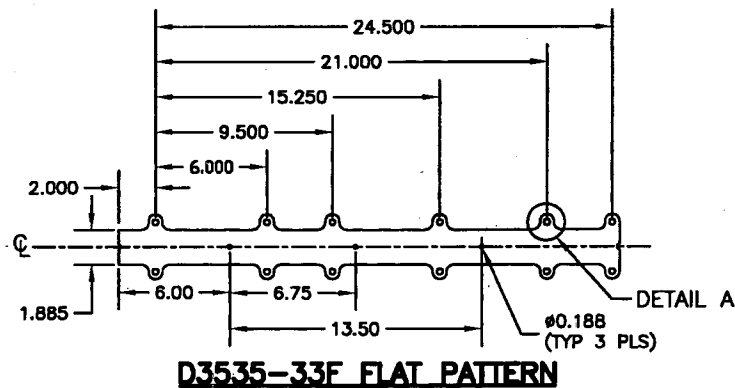
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NO. 38867



**NOTES**

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DESIGN	DRAWN BY	DART AEROSPACE USA, INC.		
CB	PH	PORT HADLOCK, WA		
CHECKED	APPROVED	DRAWING NO.	REV. B	
		D3535	SHEET 4 OF 7	
DATE		TITLE	SCALE	
07.04.17		WEARSHOE	1:10	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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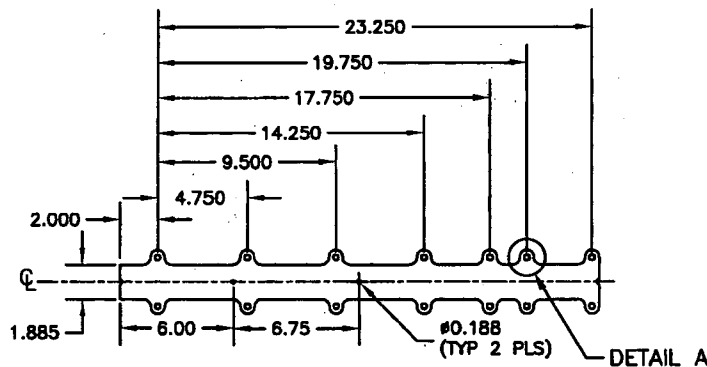
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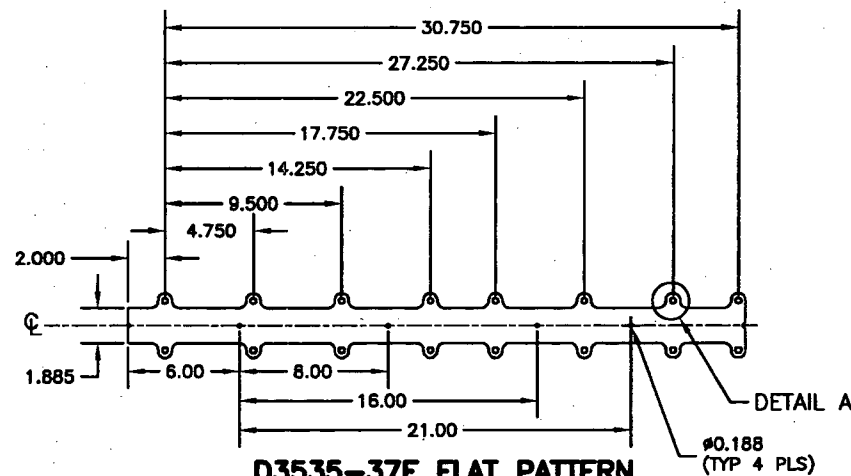
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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 5 OF 7
		SCALE
		1:10

**D3535-35F FLAT PATTERN****D3535-35 BEND DETAIL**

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**D3535-37F FLAT PATTERN****D3535-37 BEND DETAIL**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

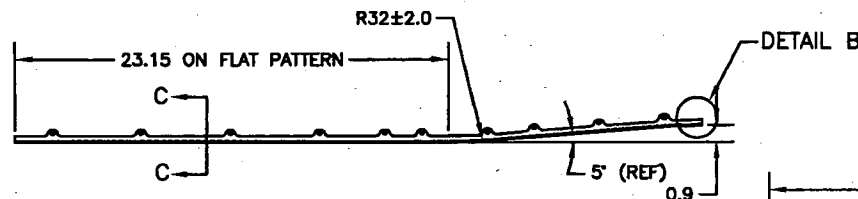
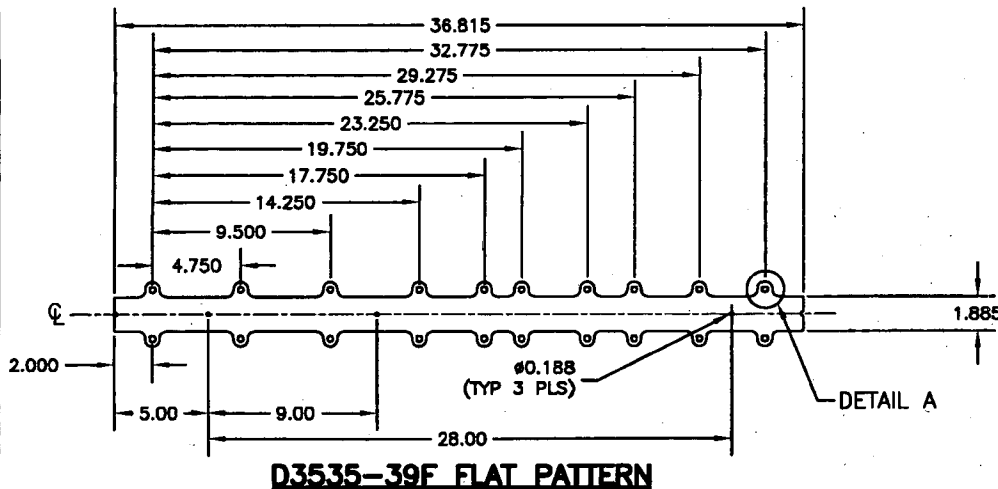
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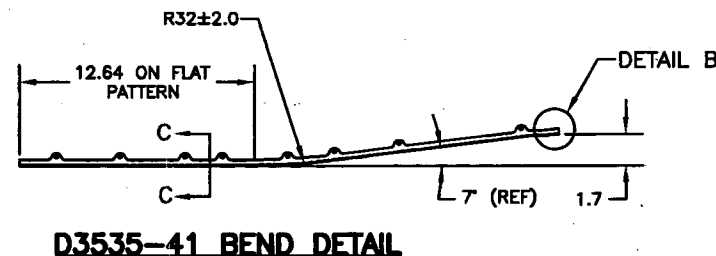
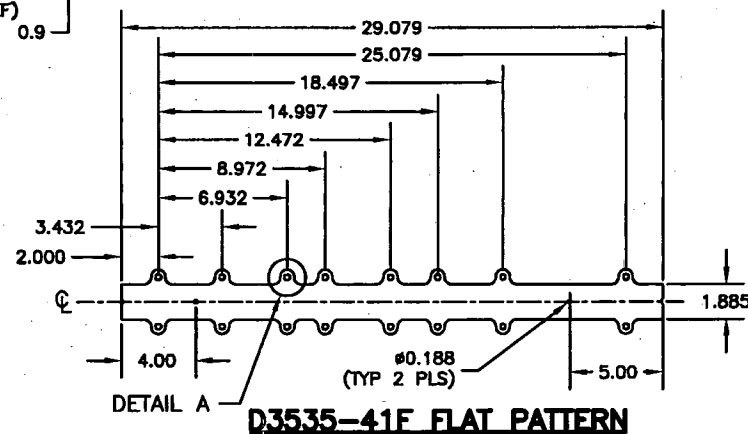
**DART**

RELEASED  
07.04.24

DESIGN	C.B.	DRAWN BY	M.H.	DART AEROSPACE USA, INC.
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	TITLE	D3535	WEARSHOE
		REVISION	B	
		SHEET	6 OF 7	
		SCALE	1:10	



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WORK ORDER  
NO. 38807



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
  - 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
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  - 8) SEE PAGE 7 FOR DETAILS AND SECTION



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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

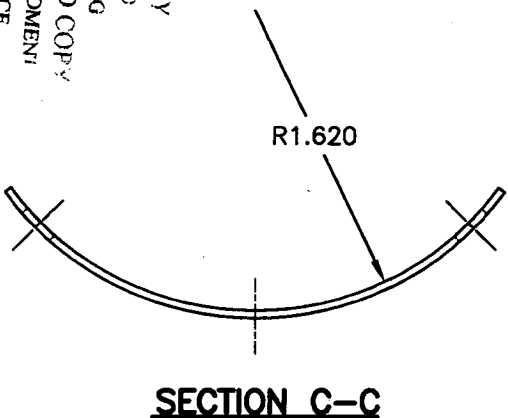
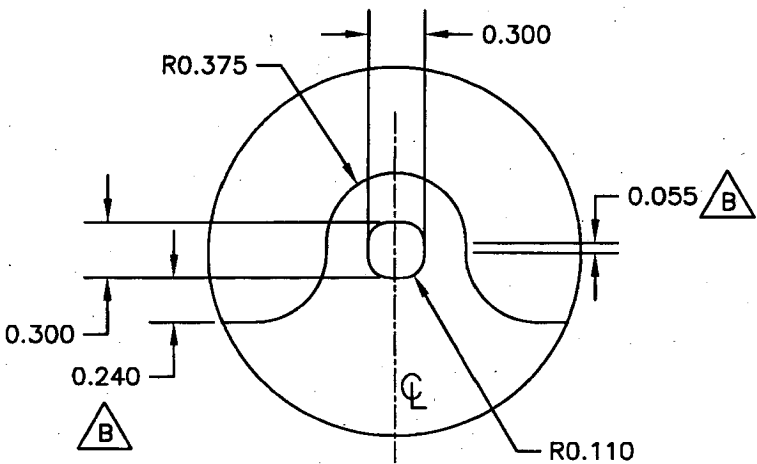
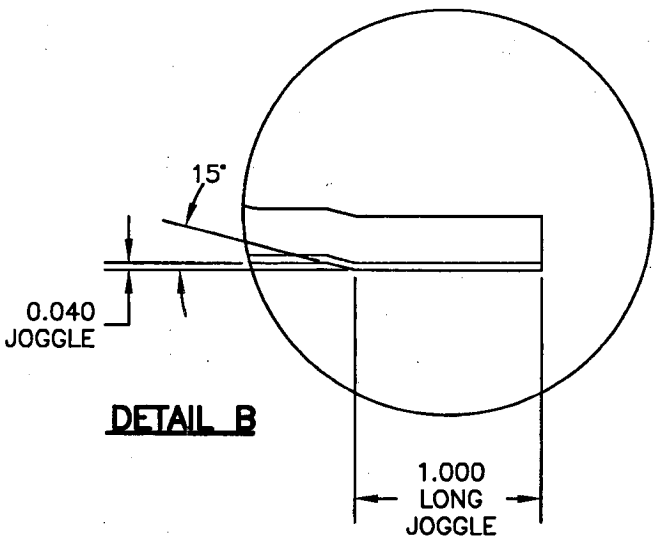
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# DART

RELEASED  
07.04.24

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B
DATE 07.04.17		TITLE WEARSHOE	SHEET 7 OF 7
		SCALE 1:1	



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WORK ORDER  
NO. 388107

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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